Date: Monday, 04/05/2009 1:46:10 PM
User: Linda Lacelle

# Process Sheet

**Customer** : CU-DAR001 Dart Helicopters Services
**Job Number** : 47687
**Estimate Number** : 11558
**P.O. Number** :
**This Issue** : 04/05/2009 **S.O. No.** :
**Prsht Rev.** : NC
**First Issue** : / / **Type** : SMALL /MED FAB
**Previous Run** : 47186
**Written By** :
**Checked & Approved By** : TMD 09.05.06
**Comment** : Est. B02.03.05 Added dwg Rev.A1 NG

**Drawing Name** : PROP ASSEMBLY
**Part Number** : D3085041
**Drawing Number** : D3085 REV A1
**Project Number** : N/A
**Drawing Revision** : A1
**Material** :
**Due Date** : 15/05/2009 **Qty:** 4 **Um:** Each

**Additional Product**

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 1.0 | D30153 | Locknut |

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Lock Nut
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 1 | D3015-3 | Locknut | B48111 |

09/06/03

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 2.0 | D30811 | Hinge |

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Hinge
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 1 | D3081-1 | Prop Hinge | 44081 (2) B47845 (2) |

09/06/03

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 3.0 | D30821 | Clip |

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Clip
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 1 | D3082-1 | Clip | B47294 |

09/06/03

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 4.0 | D30841 | Strut |

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Strut
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 1 | D3084-1 | Prop arm | B47295 |

09/06/03



Form: rprocess

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: Monday, 04/05/2009 1:46:10 PM
User: Linda Lacelle

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** PROP ASSEMBLY

**Job Number:** 47687 **Part Number:** D3085041

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 5.0 | AN45A | Bolt |

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 1 | AN4-5A | Bolt | M111650 |

09/06/03

| | | |
|---|---|---|
| 6.0 | AN960JD10 | Washer |

**Comment:** Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 3 | AN960JD10 | Washer | M111279 |

09/06/03

| | | |
|---|---|---|
| 7.0 | AN960JD10L | Washer |

**Comment:** Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 3 | AN960JD10L | Washer | M109632 |

09/06/03

| | | |
|---|---|---|
| 8.0 | AN960JD416 | Washer |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 2 | AN960JD416 | Washer | M111279 |

09/06/03

| | | |
|---|---|---|
| 9.0 | AN960JD516L | Washer |

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 1 | AN960JD516L | Washer | M114477 |

09/06/03



Form: rprocess

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: Monday, 04/05/2009 1:46:10 PM
User: Linda Lacelle

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** PROP ASSEMBLY

**Job Number:** 47687 **Part Number:** D3085041

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 10.0 | MS21042L3 | Nut |

**Comment:** Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)
Nut
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 3 | MS21042L3 | Nut(or MS21042-3) | M110844 |

09/06/03

| | | |
|---|---|---|
| 11.0 | MS21042L4 | Nut |

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 1 | MS21042L4 | Nut(or MS21042-4) | M110450 |

09/06/03

| | | |
|---|---|---|
| 12.0 | MS27039113 | Screw |

**Comment:** Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)
Screw
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 3 | MS27039-1-13 | Screw | M105211 |

09/06/03

| | | |
|---|---|---|
| 13.0 | SL69BS | Ball Stud |

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Ball Stud
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 1 | SL69-BS | Ball Stud | M109239 |

09/06/03

| | | |
|---|---|---|
| 14.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |

**Comment:** SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D3085

09/06/03 (4)

| | | |
|---|---|---|
| 15.0 | QC5 | INSPECT WORK TO CURRENT STEP |

**Comment:** INSPECT WORK TO CURRENT STEP

03/06/03 (4)



Form: rprocess

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: Monday, 04/05/2009 1:46:11 PM
User: Linda Lacelle

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** PROP ASSEMBLY

**Job Number:** 47687 **Part Number:** D3085041

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 16.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |

4C

**Comment:** PACKAGING RESOURCE #1
Identify and Stock
Location: 271 9/10/22 3P

| 17.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|---|---|---|

09/06/23 MF

**Comment:** FINAL INSPECTION/W/O RELEASE

Job Completion

MF 09-06-23



Form: rprocess

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

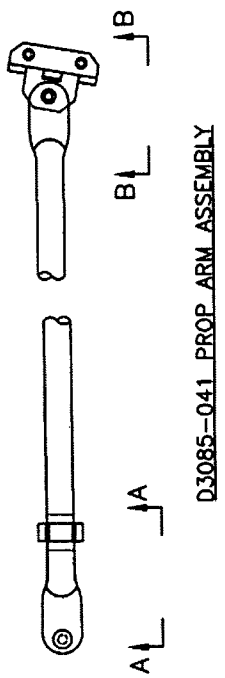
**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

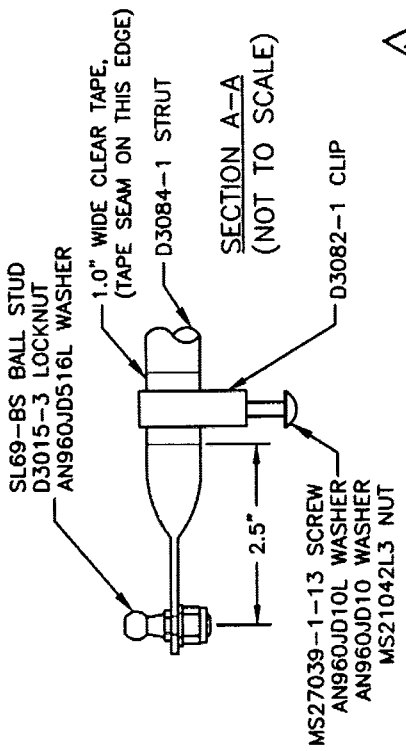
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

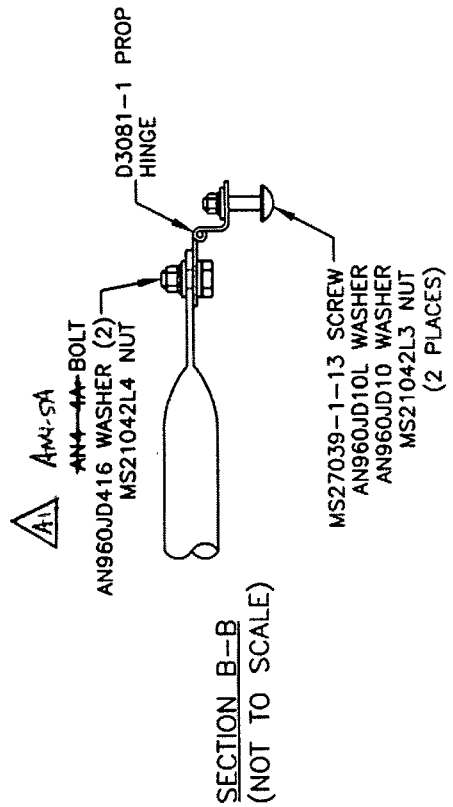
**NOTE:** Date & initial all entries

| | | | |
|---|---|---|---|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3085 | REV. A<br>SHEET 1 OF 1 |
| DATE 02.01.23 | | TITLE PROP ARM ASSEMBLY | SCALE 1:5 |
| A | 02.01.23 | NEW ISSUE | |
| A1 | # CP 02.02.25 | AN4-5A WAS AN4-4A | |

RELEASED 02-01-25 #




SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47268

**Copyright © 2002 by DART AEROSPACE LTD**
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.